

Work Order ID 131258

131258

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April-01-15 12:37:03 PM

Item ID: D4011-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp, Short
 Start Date: 4/01/15 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 4/08/15 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4011	C

100 PURCHASING 0.00

100

Waterjet
FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

0.00

(24)

04/15/04/05

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC
Quality Control

Memo

0.00

(24)

04/15/04/05

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Item ID: D4011-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Clamp, Short

Stop *NS2*

Start Date: 4/01/15 **Start Qty:** 24.00

24

Cust Item ID:

Required Date: 4/08/15 **Req'd Qty:** 24.00

24

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

APR 06 2015

130	Form as per dwg	0.00
130	NC BRAKE	
Brake NC	Memo	0.00
Brake NC		

DAS 30 9-89

APR 06 2015

DAS
28
9-89

140	QC5- Inspect part completeness to step on W/O	0.00
140		
QC	Memo	0.00
Quality Control		

DAS
38
9-89

APR 08 2015

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>SL 544</u>	0.00				24	DAS 27		
150									
Packaging	Memo	0.00							
Packaging									

APR 09 2015

160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-09

(Signature) 15-4-9

Picklist Print

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Work Order ID: 131258

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Parent Item: D4011-5

D4011-5

Parent Item Name: Clamp, Short

Start Date: 4/01/15

Required Date: 4/08/15

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP RevA: revB as per dwg 09.11.18 DD verified by:JLM IPP
Rev:B 11.05.19 MADE IN HOUSE DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased			No	100	sf	168.0000	0.066	2			

M304S14GA

304SS sheet .080

04/15/04/05

Location

Loc Qty

Loc Code

MAT019

168

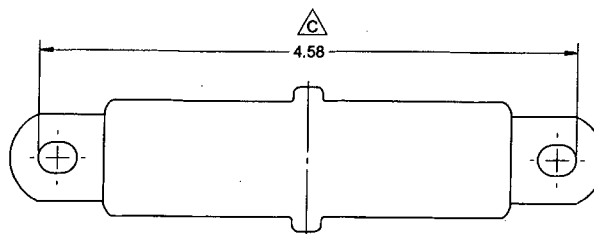
M126075

46

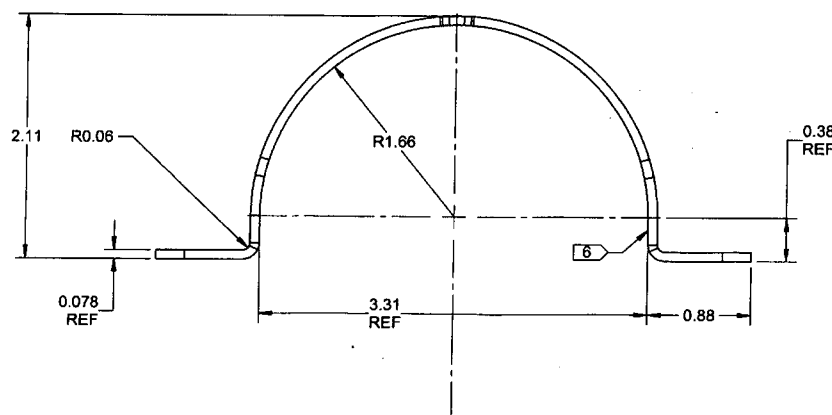
M129972

122

2.1



131258



D4011-5 CLAMP, SHORT (OEM)

RELEASED

2015 MAR 26 *up*

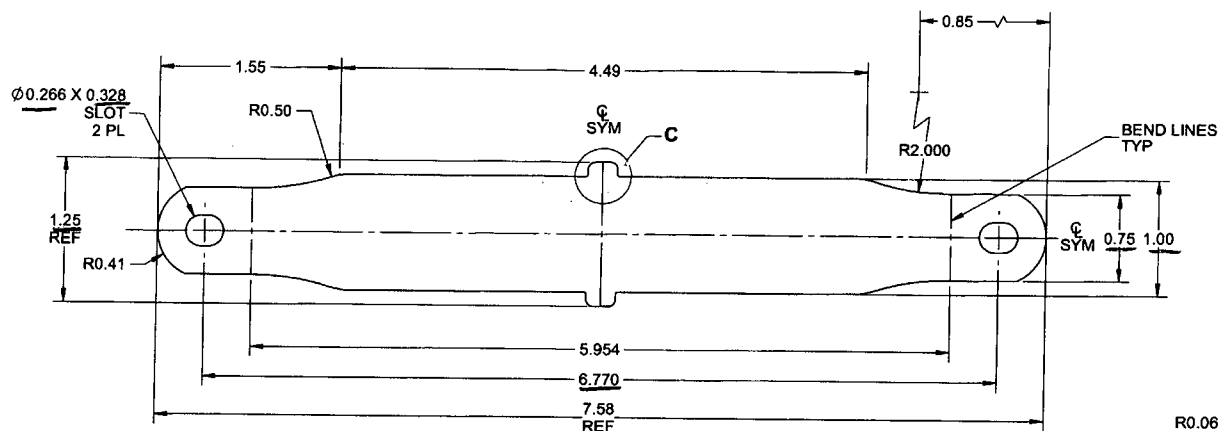


NOTES:

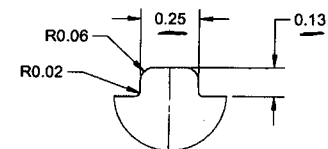
- 1) MATERIAL: MAKE FROM D4011-5F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-5" AND B/N PER QSI 044 6.1 (PERMANENT MARKER)
- 7) WEIGHT: 0.02 lbs

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 5 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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D4011-5F CLAMP, FLAT PATTERN, SHORT (OEM)



DETAIL C
SCALE 2X

RELEASED

2015 MAR 26

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs
- 8) FOR UNDIMENSIONED DETAILS, REFER TO FLAT PATTERN CAD FILE D4011-5F-RevC.DXF

APPROVED

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4011	SHEET 6 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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